

Date: Monday, 18/08/2008 3:40:49 PM  
User: Julie Lecocq

## **Process Sheet**

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG
Job Number	: 41334		
Estimate Number	: 10256		
P.O. Number	:	Part Number	: D22303
This Issue	: 18/08/2008	S.O. No.	: D2230 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Type	: MACHINED PARTS
Previous Run	: 40892	Drawing Revision	: F
Written By	:	Material	:
Checked & Approved By	: <u>JUD08.8.18</u>	Due Date	: 15/09/2008
Comment	: Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC	Qty:	200
Um:	Each		
<b>Additional Product</b>			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	D2423	Lug Extrusion	
			
Comment:	Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s)		
	Lug Extrusion		
	D2423		
	Batch: <u>B33310</u>	<u>C208/08/19</u>	
2.0	BAND SAW	BAND SAW	
			
Comment:	Band Saw	<u>Cert at 4 meters</u>	
	Cut D2423 extrusion to 0.82"		
	Batch:		
3.0	HAAS	HAAS CNC VERTICAL MACHINING #1	
			
Comment:	HAAS CNC VERTICAL MACHINING #1	<u>machines per day.</u>	<u>C208/08/19</u>
	Machine per folio D2230-3		(200)
	Check for crack while loading into the machine.	<u>D2230 New F</u>	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE	<u>read + inspect for transit damage</u>	<u>PC 08/11/12</u>
		<u>caf C attached.</u>	(200)
5.0	QC8	SECOND CHECK	
			
Comment:	SECOND CHECK	<u>Inspect level 5</u>	<u>S 08/08/16</u>
			(200)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:40:49 PM  
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Drawing Name: MOUNTING LUG

Job Number: 41334

Part Number: D22303

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

M/A S. Lecocq

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MJ 08-09-16 X200

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/16 X200

9.0 POWDER COATING

POWDER COATING



M 108523

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME: 11:00 AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 11:30 AM

MJ 08-09-16 X200

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MJ 08/09/16 X200

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

MJ 08/09/16 (200)

12.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/16 X200

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MJ 08-09-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41334
Description: Mounting Lug	Part Number:	D2230-3
Inspection Dwg: D2230	Rev: F	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

<b>Measured by:</b>	<b>Audited by:</b>	<b>Prototype Approval:</b>	N/A
Date:	Date:	Date:	

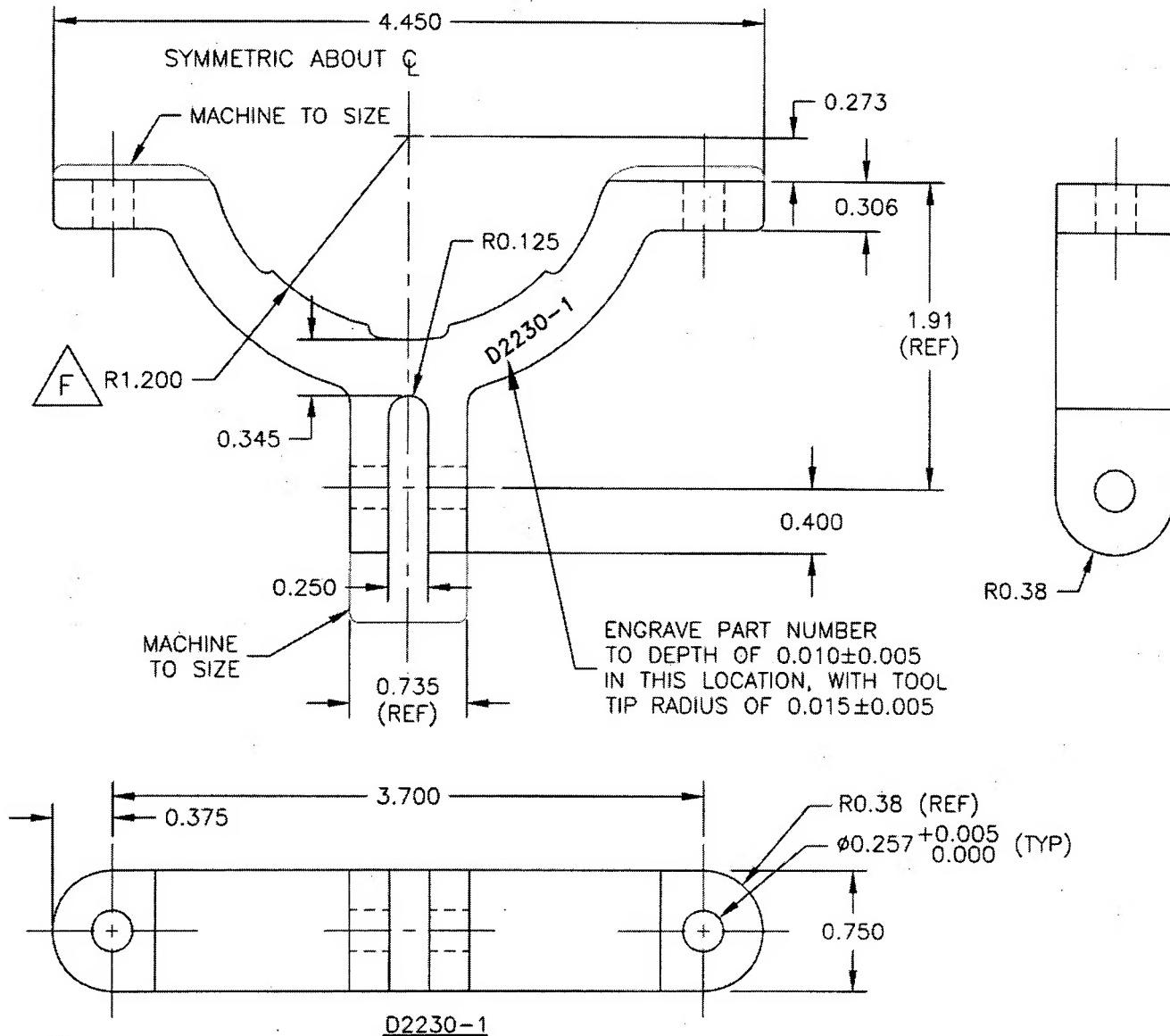
Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RF	TT



1 COPY IS  
MAILED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230 REV. F
DATE		SHEET 1 OF 2
99.12.13		SCALE 1:1
C	94.03.30	RE-DESIGN
D	95.01.04	RE-DESIGN
E	95.01.04	RE-DESIGN
F	99.12.13	REDESIGN; R1.200 WAS R1.100

RELEASED  
99.12.21 DS



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE

WORK ORDER  
NO. 41324

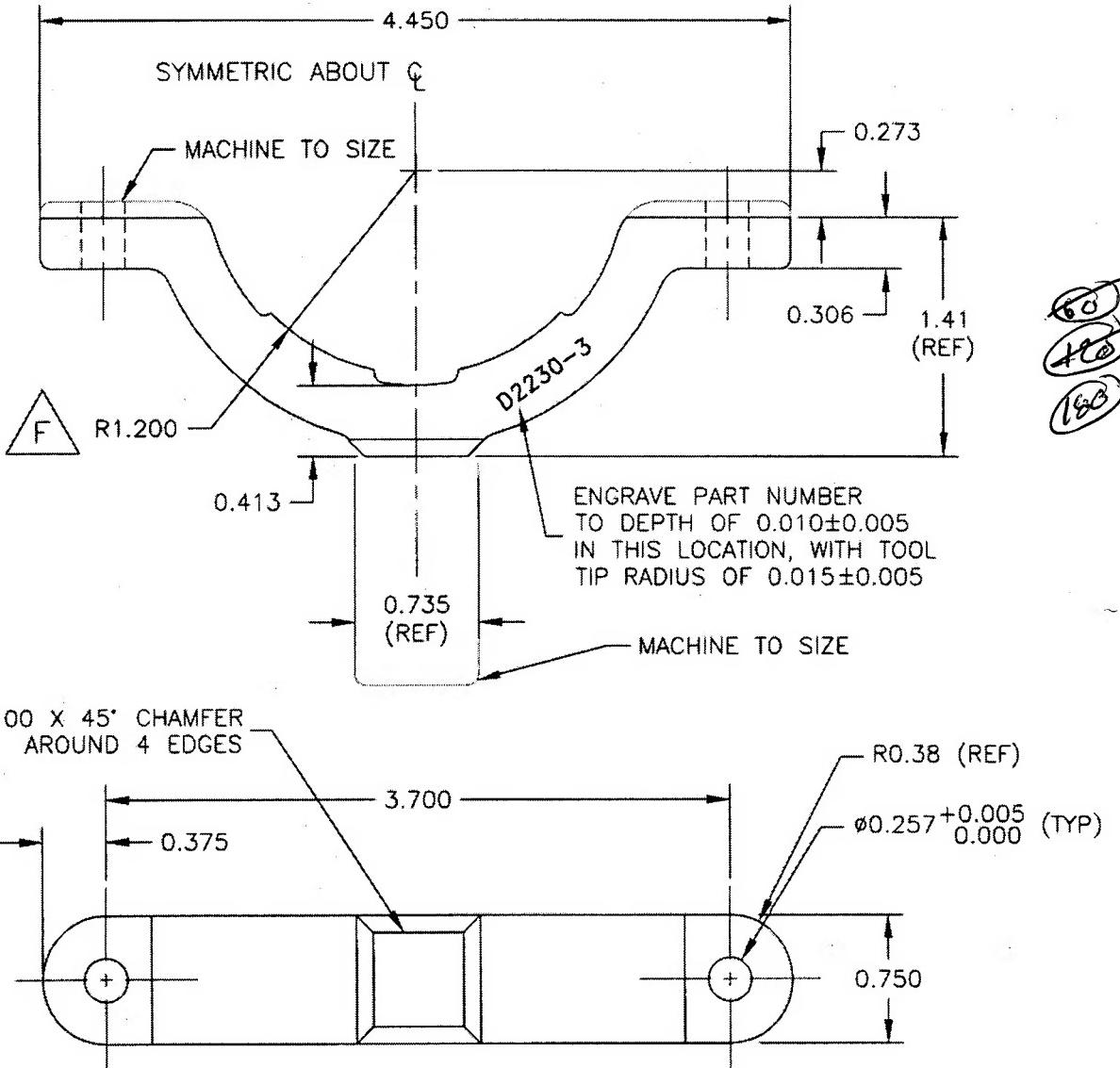
**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230 REV. F SHEET 2 OF 2
DATE		TITLE MOUNTING LUG SCALE 1:1

99.12.13

RELEASED  
99.12.21 DS



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE  
WORK ORDER  
NO. 41334



## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
200	D2230-3	Mounting Lug	6978
	MATERIAL: supplied by DART	D2423 B33310	<i>S Denise</i>

We hereby certify that the above parts were made in conformance with applicable drawings.

*METEC Metal Technology Inc.*

A handwritten signature in black ink, appearing to read "Denise" followed by a surname starting with "Robinson".

Denise Robinson

Vankleek Hill, September 12, 2008